











Date: Wednesday, 7/11/2007 3:05:19 PM  
User: Kim Johnston

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services <b>Job Number</b> : 33506 <b>Estimate Number</b> : 10698 <b>P.O. Number</b> : N/A <b>This Issue</b> : 7/11/2007 <b>Prsht Rev.</b> : NC <b>First Issue</b> : N/A <b>Previous Run</b> : 29679 <b>Written By</b> : <b>Checked &amp; Approved By</b> : <b>Comment</b> : EST REV. A 05.11.17 NEW ISSUE EC	<b>Drawing Name</b> : STEP WELDMENT  <b>Part Number</b> : D34631 <b>Drawing Number</b> : D3463 REV B <b>Project Number</b> : N/A <b>Drawing Revision</b> : B <b>Material</b> : N/A <b>Due Date</b> : 7/27/2007 <b>Qty:</b> 4 <b>Um:</b> Each	
<b>Additional Product</b> :		
<b>Job Number:</b>		
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
1.0	M316TR100W120	Inventory
		
<b>Comment:</b> Qty.: 2.1872 f(s)/Unit Total : 8.7486 f(s) AISI 316 SS seamless tubing 1.00" OD X 0.120 wall (M316TR1.00w120) Batch: M105111		FF 07-07-24
2.0	BAND SAW	BAND SAW
		
<b>Comment:</b> BAND SAW Cut blank 25.00 " long		FF 07-07-24
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 1-Bend as per dwg D3463  2-Trim to lenght per dwg D3463  3- Deburr		FF 07-07-26
4.0	QC5	INSPECT WORK TO CURRENT STEP
		
<b>Comment:</b> INSPECT WORK TO CURRENT STEP Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.		Er 07/07/26 (45)
5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		
<b>Comment:</b> CONVENTIONAL MILLING MACHINE 1- Drill as per dwg D3463  2-Deburr as per dwg D3463		070726

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/07/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 3:05:19 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33506

Part Number: D34631

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



*Jul 07-07-27*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*07-07-26*

(4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Large lot*

*Jul 07-07-27* (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

*07/07/27*

Job Completion



*Jul 07-07-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

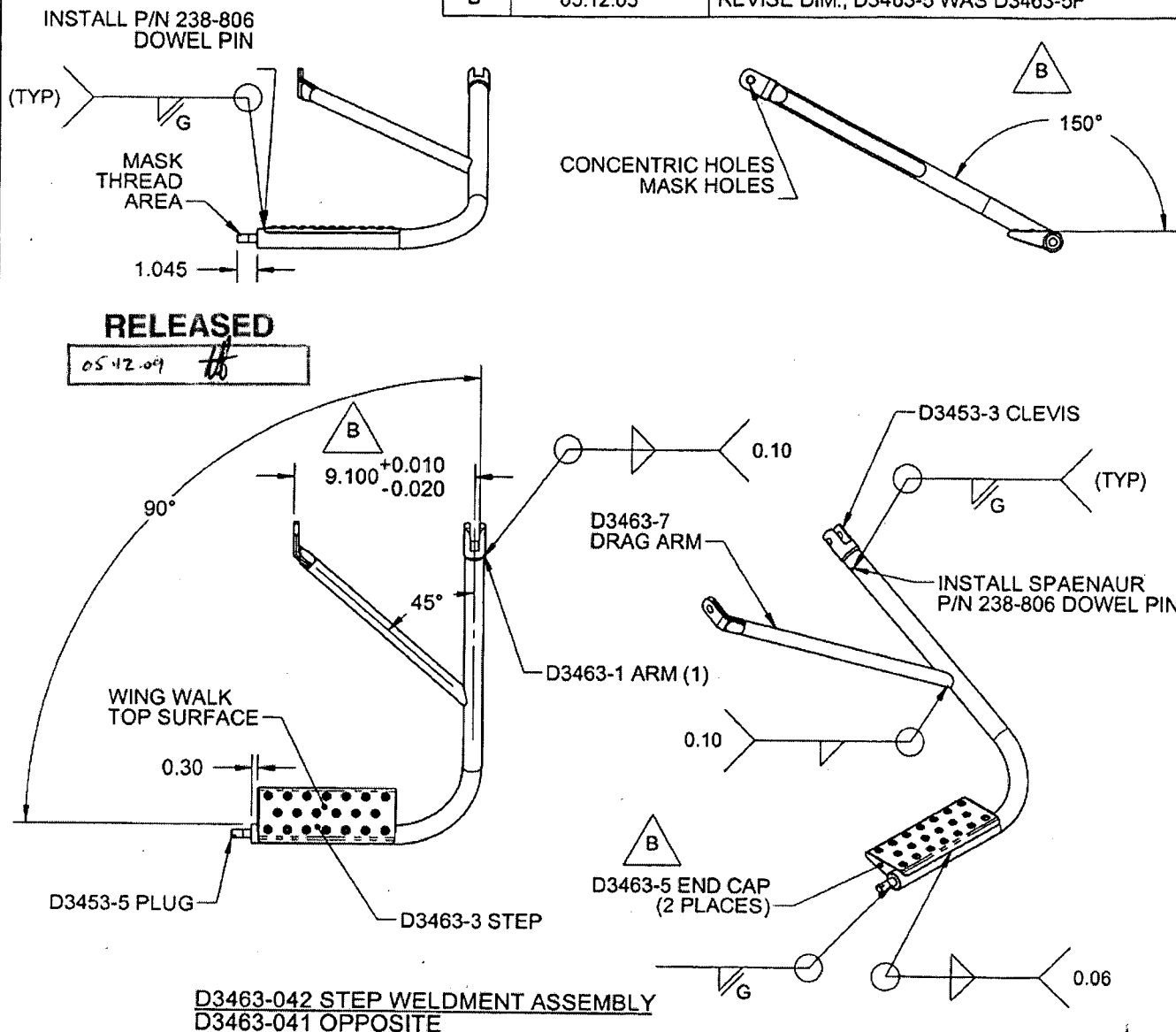
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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NO. **33506**

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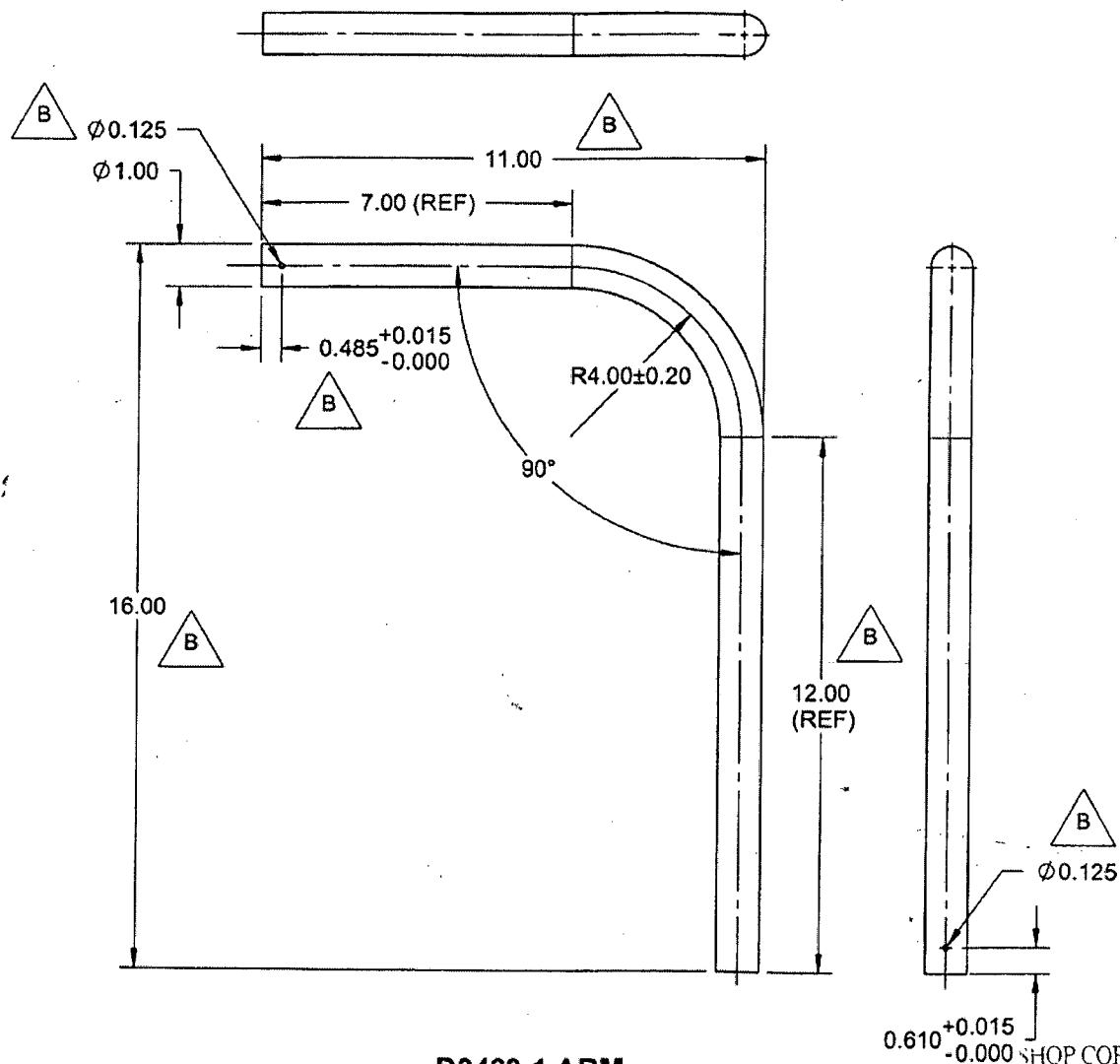
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 [Signature]



**D3463-1 ARM**

**NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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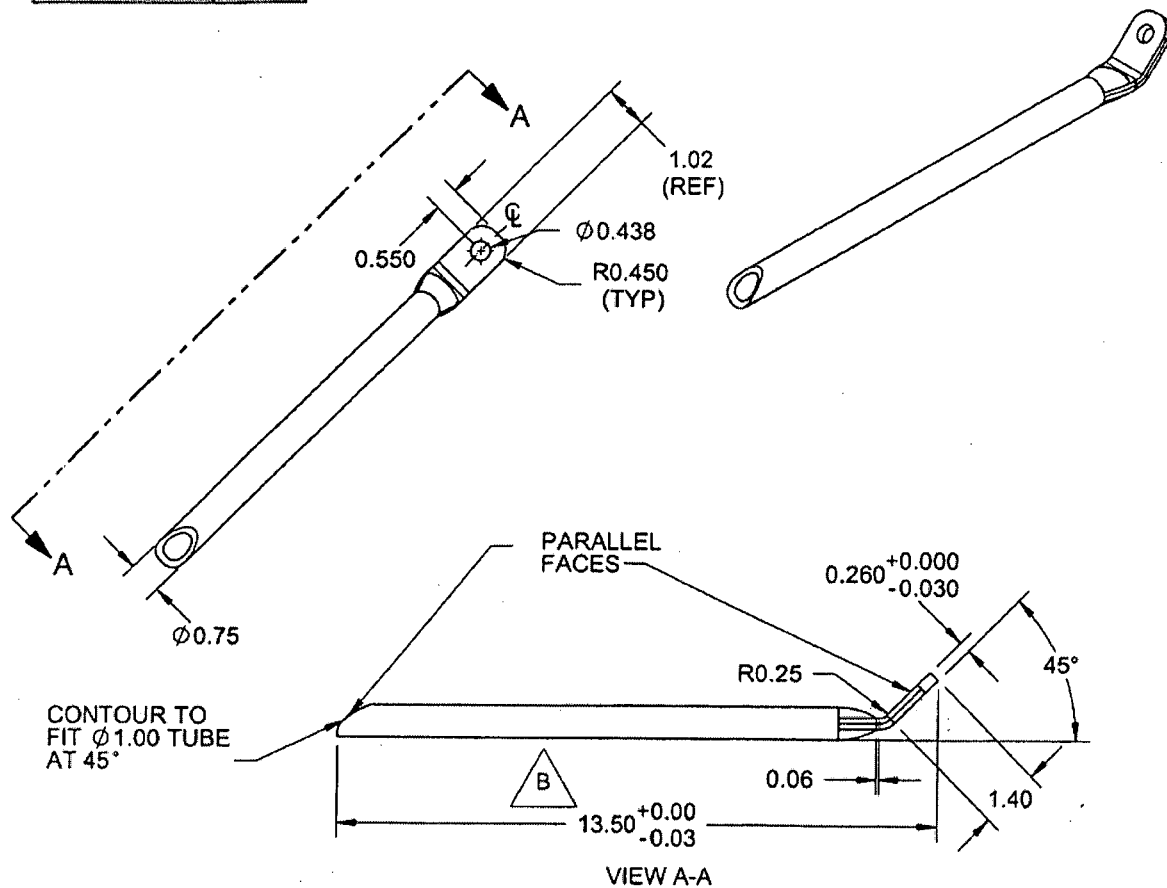
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DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 *[Signature]*



**D3463-7 DRAG ARM**

**NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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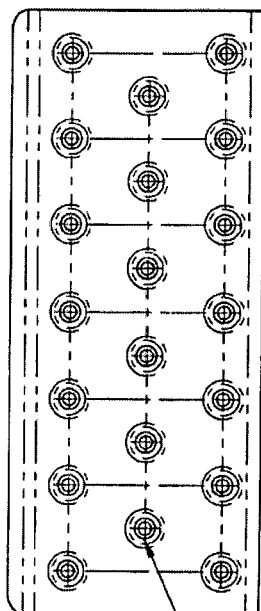
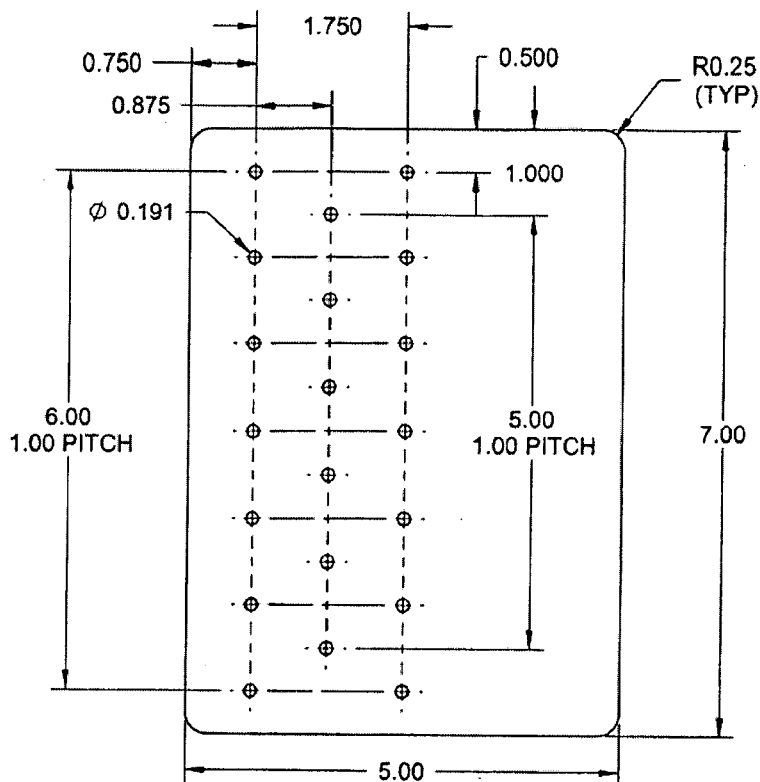
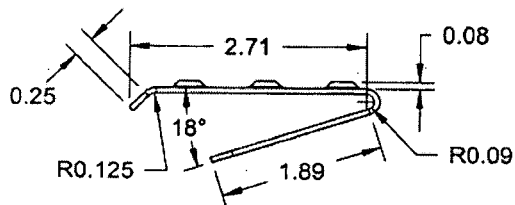
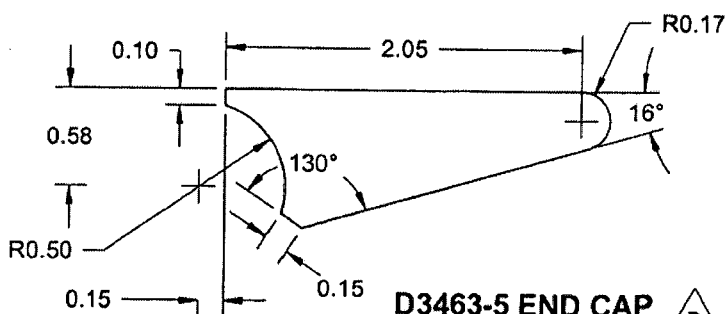


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DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:2

**RELEASED**

05.12.09 #

FORM USING  
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**

SCALE 1:1

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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